Wor	k O	rder	ID	68781
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Page 1

Thursday, April 21, 2011 8:49:46 AM

Item	ID:
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D3255-042

Accept



Setup Start

Stop



Revision ID:

Item Name:

Access Panel Assembly

Start Date:

Required Date: 4/25/2011

4/20/2011

Start Qty: 2.00

Reg'd Oty: 2.00

Cust Item ID: Customer:

Reference:

Approvals:

Process Plan:

Date:

Date:

Run Start

QC:

Date: _____ SPC (Y/N):

Tool # Plan

Code

Reject

Reject Insp.

Sequence ID/ Work Center ID

Operation Description Set Up/ **Run Hours**

Tool ID

Accept **Qty**

Oty

Stop

Number Stamp

Draw Nbr

Revision Nbr

D3255 Rev B

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Weld as per Dwg D3255 ***purge weld*** 🗆 A/R

Batch: 115778 02-Grind Welds Flush

St 1410/04

110

QC10- Inspect visual per QSI004- ground welds

Quality Control

120

QC5- Inspect part completeness to step on W/O

0.00

Quality Control

Memo

0.00

Memo

Dart Ae	rospace L	td						
W/O:		·	WO	RK ORDER CHANGE	S			*
DATE	STEP	PROC	EDURE CHAN	IGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	_ Fault Categ	jory:	NCR: Yes	No DQA:	Date: _	
	Res	olution:	_ Disposition	:	QA: N/C Cld	osed:	Date: _	
NCR:		W	ORK ORDE	R NON-CONFORMA	NCE (NCR	3)		
		Description of NC		Corrective Action Section		Verification	1 Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Orde Thursday, April		781 9:46 AM				e e			Page 2
Item ID: Revision ID:	D3255-042			Accept			Setup	Start	
Item Name: Start Date: 'Required Date: Reference:	Access Panel 4/20/2011 4/25/2011	Start Qty: 2.00 Req'd Qty: 2.00			Cust Item ID: Customer:			Stop	
Approvals:	Process Pla	n:	Date:	Tooling: SPC (Y/N):	Date:	- 	Run	Start Stop	
Sequence ID/ Work Center II 130 Powdercoat Powder Coating 140 QC Quality Control	, 3480	Operation Description Grey Sandtex(Ref.4.3.5.6 Memo START TIM QC3- Inspect Part Finish Memo	1200	Set Up/ Run Hours 0.00 0.00 OVEN TEMPERATUR 0.00 0.00		Plan Accep Code Qty	Qt.	M	Reject Insp. Number Stamp

0.00

0.00

1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg D3255 DA/R 736 DOW CORNING ADHESIVE Batch: 11/666

150

Small Fab

Small Fab

Small Fab

Memo

W/O:					ORK ORDER CHANG	EC	······································	· · · · · · · · · · · · · · · · · · ·	τ.
								Approval	Approval
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	R	lesolui	tion:	Disposit	ion:	_ QA: N/C Cld	osed:	Date: _	
NCR:	-			WORK OR	DER NON-CONFORM	ANCE (NCR)		
			Description of NC			tion B	Verification	Approval	Approval
DATE	STEP		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
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Work Order ID 68781

Thursday, April 21, 2011 8:49:46 AM



Page 3

Item ID:

D3255-042

Accept

Setup Start



Revision ID:

Item Name:

Access Panel Assembly

Start Date:

4/20/2011

QC:

Start Qty: 2.00

Req'd Qty: 2.00



Date:

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: _____

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

Stop

Stop



Required Date: 4/25/2011

Sequence ID/ Work Center ID

160

Quality Control

Operation Description

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location 5-176

Set Up/ **Run Hours**

0.00

Tool ID

Tool # Plan Code Accept Qty

Reject Qty

Reject Insp. Number Stamp

170

Packaging Packaging

Memo

Memo

0.00

180

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

- 11/10/11 TX) MF,1-10-07

W/O:			W	ORK ORDER CHANGI	ES			t.
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Picklist Print

Thursday, April 21, 2011 8:49:52 AM

Work Order ID: 68781

D3255-042 Parent Item:

Parent Item Name: Access Panel Assembly



Start Date: 4/20/2011

Required Date: 4/25/2011

Page 1

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
03255-2		Manufactured	No			100	Each	1.0000		2 3716=	186		M 11/10
				Location		Loc	<u>Oty</u>	Loc Code					
				WA025			1		_			•	
					61686		1		-		_		
03255-5 11 11 11 11 11 11 11 11 	 1	Manufactured	No			100	Each	2.0000		2	1/60/	106	
				Location		Loc	<u>Oty</u>	Loc Code					
		-		GA			2	1211	8 2	<u> </u>	_		
					66574		2	•	-		_		
03255-3		Manufactured	No			150	Each	17.0000	1	2		_	1.1.
a Cap										BAJ	152	(V)_	MILL
				Location		Loc	<u>Otv</u>	Loc Code					
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					66812		17						

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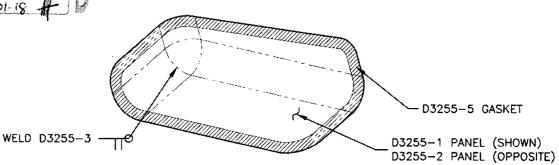
W/O:			W	ORK ORDER CHANGI	ES			
DATE	STEP	PRO	DCEDURE CHA	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector
							Prod Mgr	
		·						
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA:	Date: _	
	Re	solution:	Dispositio	n:	_ QA: N/C Cld	sed:	Date: _	
NCR:			WORK ORD	ER NON-CONFORMA	NCE (NCR)		
DATE	CTED	Description of NC		Corrective Action Section		Verification	Approval	Approval
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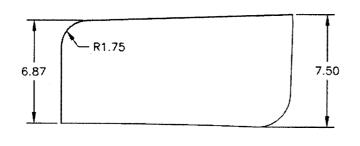
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 04.1	2.06		ACCESS PANEL ASSEMBLY		1	:6
Α		04:01.27	NEW ISSUE			

04.12.06 | D3255-3 REDESIGN; ADDED Ø0.098

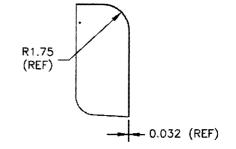


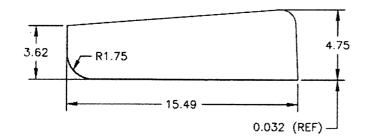


D3255-041 ACCESS PANEL (SHOWN) D3255-042 ACCESS PANEL (OPPOSITE)



В





SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE WORK ORDER NO. 4578/

p/11-04-21

D3255-1 BEND DETAIL D3255-2 OPPOSITE

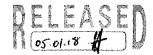
D3255-041/-042 NOTES:

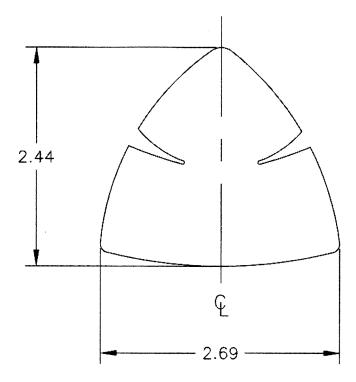
- WELD PER DART QSI 004
- FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3 INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

W/O:		·	W	ORK ORDER CHANG	ES					
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04.12.06		TITLE	1:1





W/068781

D3255-3 CAP FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

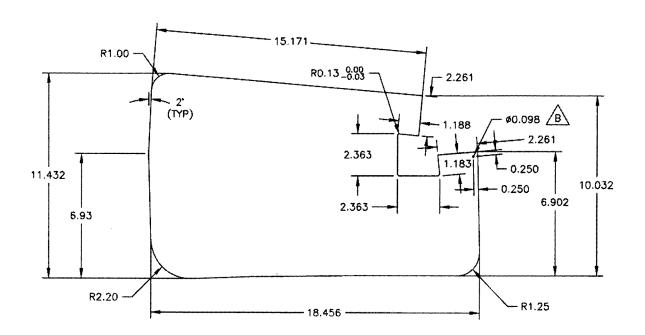
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DATE	Section A		Initial Chief Eng			Se	ction C	Chief Eng	QC Inspector



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04.12.06		ACCESS PANEL ASSEMBLY	1:5





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D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

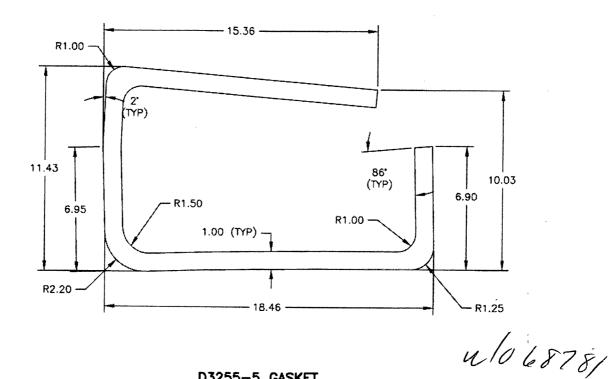
- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLÈSS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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D3255-5 GASKET

D3255-5 NOTES:

1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F P/N SIL/F 36x36x1/16 POSSIBLE SUPPLER: AVIALL

2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

3) ALL DIMENSIONS ARE IN INCHES

W/O:			W	ORK ORDER CHA	NGES	, , ,				
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